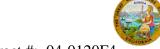
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: xx.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-019708

Address: 333 Burma Road **Date Inspected:** 26-Nov-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location: SHANGHAI CHINA** 

**CWI Name: CWI Present:** Yes No Mr. An Qing Xing. **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component: OBG TRIAL ASSEMBLY** 

## **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

CB # 16

Shielded Metal Arc (SMAW) welding of Weld Joint FB203-016-010 (CB 16), And Welder is identified as 041713; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS- B-P-2114-FCM-1.

Lift 11W

Flux Cored Arc (FCAW) welding of Weld Joint TRIC-PP102-006 (11W, Traveler Rail Bracket), And Welder is identified as 053486; ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4c-F.

LIFT 11W:-

Shielded Metal Arc (SMAW) welding of Weld Joint SEG071A-044 (11DW,CW Side), And Welding Repair

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Report(WR)B-WR17735, Welder is identified as 046709; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

Shielded Metal Arc (SMAW) welding of Weld Joint 0BW11C-009 (11DW+11EW,SP-SP,CB Side), And Critical Welding Repair Report(CWR)B-CWR2269, Welder is identified as 046704; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-FCM-Repair.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG073A-013 (11EW,CW Side), And Welding Repair Report(WR)B-WR17735, Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07503

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bike Path Cantilever Beam welds. The weld designations reviewed are as follows.

- 1. BK001-048-005,006,007,009
- 2. BK001-049-005,006,007,009

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07502

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as 11EW PP108 Strengthen Plate welds. The weld designations reviewed are as follows.

1. CSD9-PP108-150~153

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

**Inspected By:** Tharikoppada, Reddy Quality Assurance Inspector **Reviewed By:** Miller,Mark QA Reviewer